

Work Order ID 53164

October 23, 2009 2:42:36 PM



Page 1

Item ID: D3883-1
 Revision ID: B
 Item Name: Saddle, Outboard LH
 Start Date: 23/10/2009 Start Qty: 4.00
 Required Date: 30/10/2009 Req'd Qty: 4.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: PL Date: 09/10/23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3883	B								
100		0.00							
	HAAS CNC VERTICAL MACHINING #1						4		
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Program Batch No. <u>853164</u> Double check by: <u>B.A.</u> 1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB						4		
QC	Memo	0.00							
Quality Control									

mw
 09/10/29

mw
 09/10/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3883-1 PAR #: N/A Fault Category: Mach. NCR: ☒ Yes ☐ No DQA: M Date: 09-11-06
 Resolution: Acceptable Disposition: Use as is QA: N/C Closed: 7 Date: 09-11-17

NCR: 53164		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.10.30	100	Saddle-to-tube ridge is 0.267" (DWG = 0.250). original ever R.C. LCA	CP 09.10.30 per QSI 042	Acceptable	mmw 09/10/30	CP 09.10.03 per QSI 042	CP 09.10.30 per QSI 042	8 01/11/03

NOTE: Date & initial all entries

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Item ID: D3883-1

Accept



Setup Start



Revision ID: B

Stop



Item Name: Saddle, On-board LH

Start Date: 23/10/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

SB 09/10/31

4

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

BL 09-11-2

4

HandFinish

Memo

0.00

Hand Finishing

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BL 09-11-2

4

Powdercoat

Memo

0.00

Powder Coating

11:40
START TIME: *3:20*
OVEN TEMPERATURE: *320*
FINISH TIME: *12:10*

October 23, 2009 2:42:36 PM



Accept

**Setup Start**

Stop



Start Date: 23/10/2009 **Start Qty:** 4.00

**Cust Item ID:**

Required Date: 30/10/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: 404



Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release



QC

Memo

0.00

0.00

Quality Control

9/4/3 (4x) 58

09/11/03

MF
09-11-03

Picklist Print

October 23, 2009 2:42:41 PM

Page 1

Work Order ID: 53164



Parent Item: D3883-1RevB



Parent Item Name: Saddle, Outboard LH

Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-015RevB		Manufactured	No			100	Each	20.0000	4.0000			

Saddle Billet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MACHINING

51834

20

20

mt 09/11/09 203
51834

DART AEROSPACE LTD		Work Order:	
Description: Saddle, Outboard, LH		Part Number: D3883-1	
Inspection Dwg: D3883 Rev. B		Page 1 of 1	

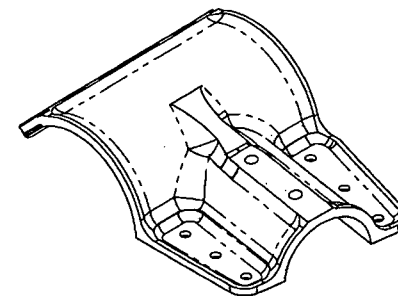
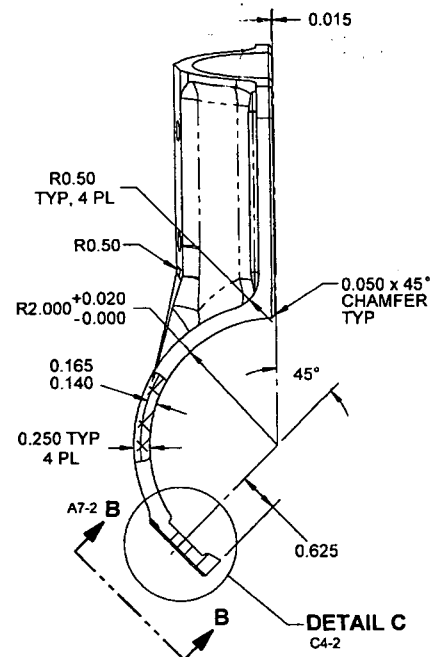
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	2.870	2.880		2.874	2.875	2.875	2.875		
B	1.433	1.443		1.436	1.435	1.436	1.436		
C	0.638	0.658		.645	.645	.645	.644		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.260	.260	.260	.260		
F	0.605	0.625		.611	.612	.610	.612		
G	1.120	1.130		1.126	1.126	1.126	1.126		
H	2.245	2.255		2.250	2.252	2.252	2.250		
I	2.000	2.020		2.004	2.004	2.004	2.004		
J	0.140	0.165		.154	.154	.153	.153		
K	0.240	0.260		.252	.250	.250	.250		
L	0.115	0.135		.124	.124	.124	.124		
M	0.140	0.165		.150	.152	.152	.152		
N	0.720	0.780		.742	.748	.754	.750		
O	0.240	0.260		.258	.258	.270	.267		
P	0.110	0.140		.140	.140	.140	.140		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.872	2.870	2.869	2.870		
S	0.316	0.321		.320	.320	.320	.320		
T	0.990	1.010		1.003	1.003	1.003	1.003		
U	1.745	1.755		1.746	1.746	1.745	1.745		
V	5.990	6.010		6.000	6.000	6.002	6.001		
W	1.245	1.255							
X	0.490	0.510		.497	.498	.498	.500		
Y	1.220	1.280		1.256	1.260	1.266	1.250		
Z	2.495	2.505		2.497	2.500	2.499	2.497		
AA	0.313	0.318		.316	.316	.316	.316		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218					
AE									
AF									
Accept/Reject									

Measured by: <i>mw</i>
Date: 09/10/30

Audited by: <i>SL</i>
Date: 09/10/31

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	<i>[Signature]</i>







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WITHOUT
WORK COPY
NO. 53164
PL 09-10-23

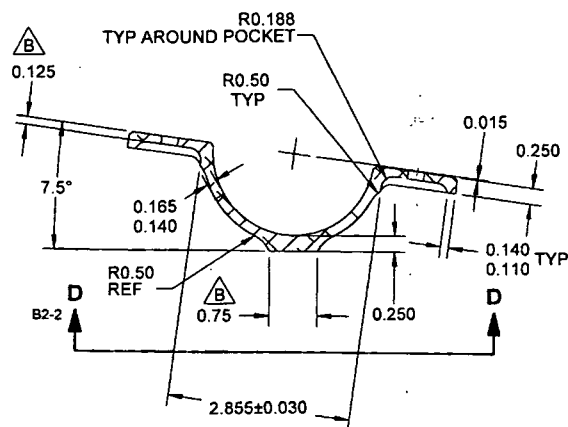
RELEASE
09/07/15

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.00 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.250

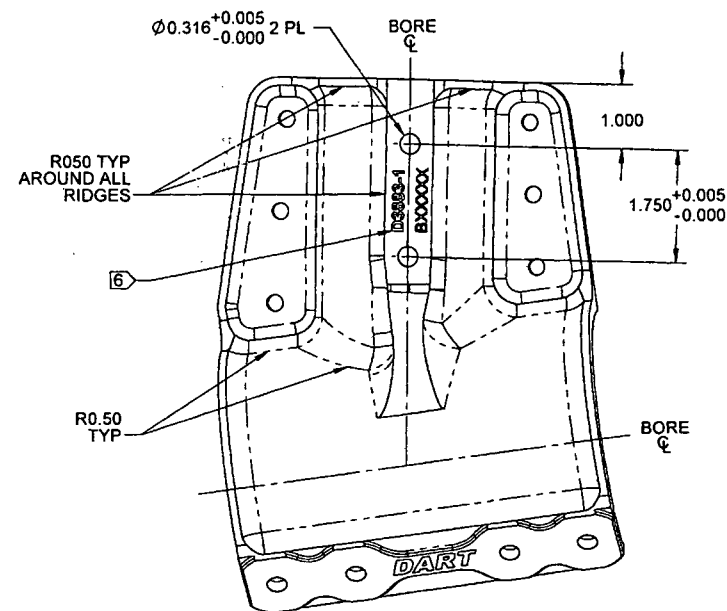
B	D6101-015 WAS D6102-015. ZN A7-1; ADD 0.648. ZN D7-1; ADD 0.615. ZN D6-1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2		RF	09.06.30
A	NEW ISSUE		RF	09.03.30
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.		
DRAWN	RF	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV.	
MFG. APPR.		D3883	SHEET 1 OF	
APPROVED		TITLE	SCALE	
DE APPR.		OUTBOARD SADDLE		NT
DATE	09.06.30			

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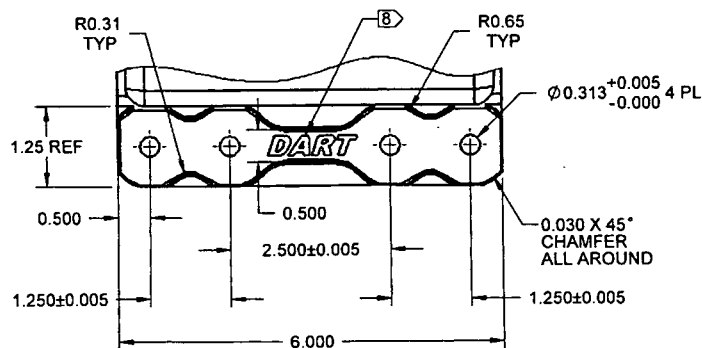


SECTION A-A C7-1

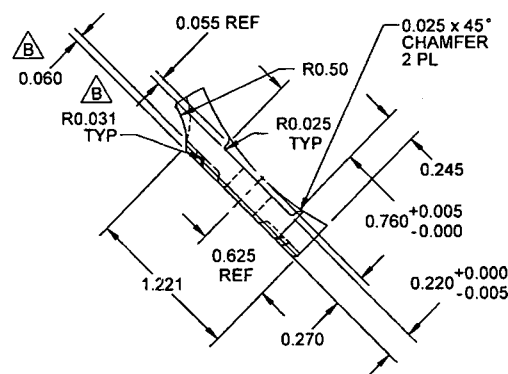
SHOW
RETURNED
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SUBJECT TO
WITHOUT
WORK
NO. 53164



VIEW D-D C7-2



VIEW B-B B4-1
(ROTATED FOR CLARITY)



DETAIL C B3-1
SCALE 2X

RELEASED
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3883	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OUTBOARD SADDLE	NTS
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